

Date: Monday, 14/01/2008 10:12:22 AM
 User: Linda Lacelle

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 36714 - 1					
Estimate Number	: 12712					
P.O. Number	:		Part Number	: D35371		
This Issue	: 14/01/2008	S.O. No. :	Drawing Number	: D3537 REV C		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: //	Type : SMALL /MED FAB	Drawing Revision	: C		
Previous Run	: 36426		Material	:		
Written By	:		Due Date	: 25/01/2008		
Checked & Approved By	:		Qty:	100 Um: Each		
Comment	: Est Rev: A New Issue 07-02-14 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
		12	
		Comment: Qty.: 0.1113 sf(s)/Unit Total : 11.1300 sf(s) M304S16GA .063" 304 SS SHEET Batch: 106653 HB 8-1-15	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C HB 8-1-15 Prog Rev: C	(107)
		2-Deburr if necessary HB 8-1-15	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		HB 8-1-15	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	(107)
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1	SB 08/01/21 (107)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/01/2008 10:12:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPAD
Job Number: 36714		Part Number: D35371
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
Qty	Description	Batch
A/R	2059B Hardcoat	M106834
1-Weld as per Dwg D3537 using Jig DT 8210		
2-Remove any weld that penetrated through Wearpadif necessary		
7.0	QC9 	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		
8.0	QC5 	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
9.0	POWDER COATING 	POWDER COATING
Comment: POWDER COATING		
M106442 Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		
10.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
11.0	PACKAGING 1 	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		
Identify and Stock Location: F20		
12.0	QC21 	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		ini 2008/2/06 V 48

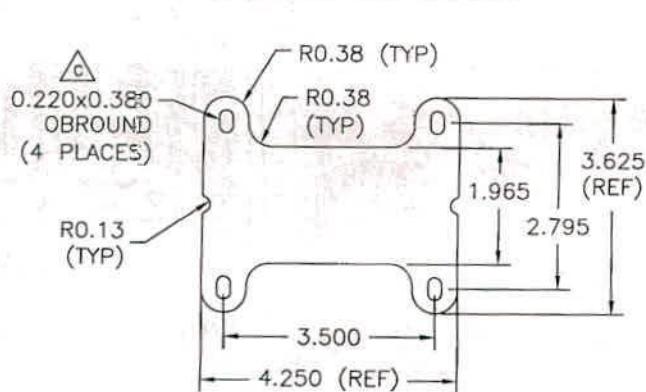
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

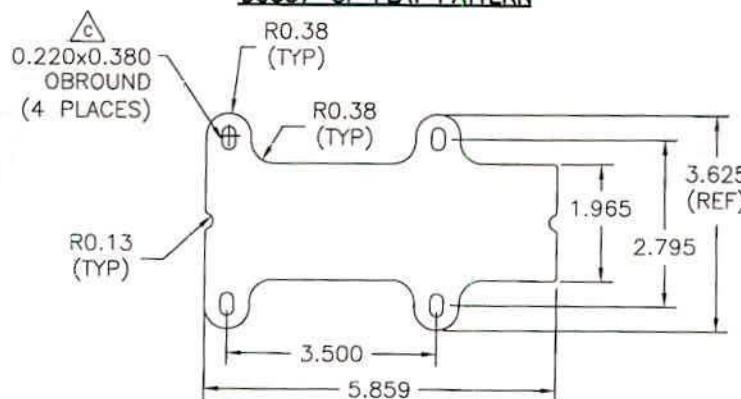
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

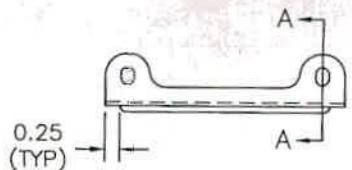
D3537-1F FLAT PATTERN



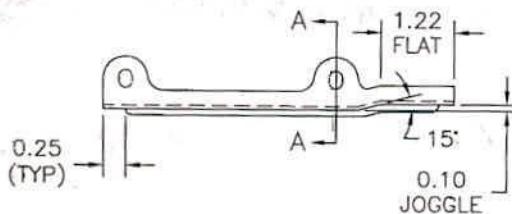
D3537-3F FLAT PATTERN



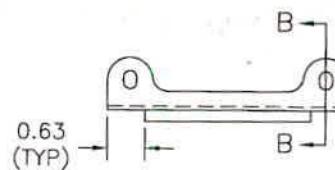
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



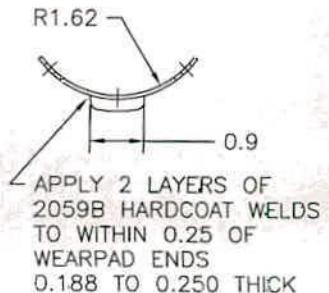
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



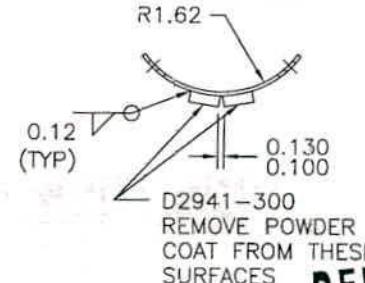
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A

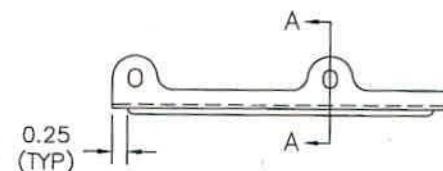


SECTION B-B



RELEASED
07.08.08 A4
PC/ECN

D3537-7 LONGITUDINAL BEND 952 (MADE FROM D3537-3F)



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DESIGN	DRAWN BY	DART	AEROSPACE USA, INC. PO BOX 200, RADCLIFFE, MA
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN	
B	07.03.20	ADD AMS 5513 AND AMS 5524	
A	06.11.06	NEW ISSUE	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D3537	SHEET 1 OF 1
DATE	07.04.13	TITLE	WEARPAD
		SCALE	1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36714
Description: WEAR PAD	Part Number:	D3537-1
Inspection Dwg: D3537-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	HB	Audited by:	J	Prototype Approval:	/
Date:	8-1-15	Date:	08/01/15	Date:	/

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

